


Date: Thursday, 02/11/2006 8:21:02 AM
 User: Linda Lacelle

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : COUPLING BRACKET |
| Job Number : 29180 | |
| Estimate Number : 11385 | |
| P.O. Number : <i>N/A</i> | Part Number : D3225041 |
| This Issue : 02/11/2006 S.O. No. : <i>N/A</i> | Drawing Number : D3225 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : MACHINED PARTS | Drawing Revision : A |
| Previous Run : 29180 | Material : <i>N/A</i> |
| Written By :  | Due Date : 07/11/2006 Qty: 2 Um: Each |
| Checked & Approved By : _____ | |
| Comment : Est. A 03.10.23 New issue KJ/DS esr b 06.10.31 waterjet ec | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S050 | 2024-T3 .050 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.1093 sf(s)/Unit Total : 0.2186 sf(s)
 2024-T3 .050 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050)
 Identify for D3225-1
 Batch: *M19053* *MM 06 11 02*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3225
 Dwg Rev: *A*
 Prog Rev: *A*

MM 06 11 02

(2)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM 06 11 02

(2)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

MM 06/11/02

MM 06/11/07 ①

(2)



Date: Thursday, 02/11/2006 8:21:02 AM
User: Linda Lacelle

SHIP 08/14
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COUPLING BRACKET

Job Number: 29180

Part Number: D3225041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3225. Dimple rivet hole.

SB 06/11/07
SB 04/11/07

PTO

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/07

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4/ 06/11/07 X2

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

4/ 06/11/07 X2

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/11/07

PTO

10.0

7C124W

CAMLOC



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

CAMLOC

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | 7C124W | Camloc | M102625 |

M102625

SB 06/11/07

PTO

11.0

MS20426AD57

Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rivet

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|--------|
| 1 | MS20426AD5-7 | Rivet | M17691 |

M17691

A/R Contact Cement

M100374

SB 06/11/07

Date: Thursday, 02/11/2006 8:21:02 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COUPLING BRACKET

Job Number: 29180

Part Number: D3225041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3225-3/-5 packers from D2397 rubber as per Dwg

D3225.Batch: B 16979

Assemble as per Dwg D3225.

Bond D3225-3/-5 to camloc using contact cement.

Identify as D3225-041

-?

SB 06/11/09 (2)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AL 06/11/09 (2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kwik Float Cell

Location: _____

U 06.11.09 2

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/11/09 (2)

Job Completion



MUST SHIP NOV. 8th 2006

Dart Aerospace Ltd.

Date: Thursday, 10/26/2006 8:25:22 AM
User: Kim Johnston

Process Sheet











| | |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : COUPLING BRACKET |
| Job Number : 29180 | |
| Estimate Number : 11385 | |
| P.O. Number : | Part Number : D3225041 |
| This Issue : 10/26/2006 S.O. No. : | Drawing Number : D3225 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : A |
| Previous Run : | Material : |
| Written By : <u> </u> | Due Date : 11/7/2006 Qty: 2 Um: Each |
| Checked & Approved By : <u> </u> | |
| Comment : Est. A 03.10.23 New issue KJ/DS | |

Additional Product

un

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|---|---|
| 1.0 | M2024T3S050 | 2024-T3 .050 sheet |
| |  |  |
| Comment: Qty.: 0.1093 sf(s)/Unit Total : 0.2186 sf(s) 2024-T3 .050 sheet Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3225-1 Batch: <u> </u> | | |
| 2.0 | SHEAR | SHEAR |
| |  |  |
| Comment: SHEAR Cut blank: 2.785" x 4.920" grain along 4.920" | | |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| |  |  |
| Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA378 and Dwg D3225 Stack of 10 Deburr break all unmarked sharp edges 0.005 to 0.010 Identify as D3225-1 | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| |  |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| |  |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3225. Dimple rivet hole. | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 06/11/09 | 10 | Transfer Hole from bracket to Camloc and dimple rivet hole and use rivet took a (-7) rivet and grind down to (-5) | EE | 06.11.09 | | u 06.11.09 | EE |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/10
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/11/07 | 5 | Part was bent on wrong side (1 scrap) | EE 06/11/07 | destroy and replace | EE 06/11/07 | EE 06/11/07 | EE 06/11/07 | EE 06/11/10 |
| 06/11/07 | 10 | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 10/26/2006 8:25:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COUPLING BRACKET

Job Number: 29180

Part Number: D3225041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----|--------------|
| 6.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

| | | |
|-----|-----------------|----------------------------|
| 7.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

| | | |
|-----|----------------|----------------|
| 8.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

| | | |
|-----|-----|---|
| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

| | | |
|------|--------|--------|
| 10.0 | 7C124W | CAMLOC |
|------|--------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

CAMLOC

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | 7C124W | Camloc | |

| | | |
|------|-------------|-------|
| 11.0 | MS20426AD57 | Rivet |
|------|-------------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivet

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|-------|
| 1 | MS20426AD5-7 | Rivet | |

A/R Contact Cement

| | | |
|------|-------------|-------------------------------|
| 12.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
Fabricate D3225-3/-5 packers from D2397 rubber as per Dwg
D3225.Batch: _____
Assemble as per Dwg D3225.
Bond D3225-3/-5 to camloc using contact cement.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 10/26/2006 8:25:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COUPLING BRACKET

Job Number: 29180

Part Number: D3225041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Identify as D3225-041

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kwik Float Cell

Location: _____

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

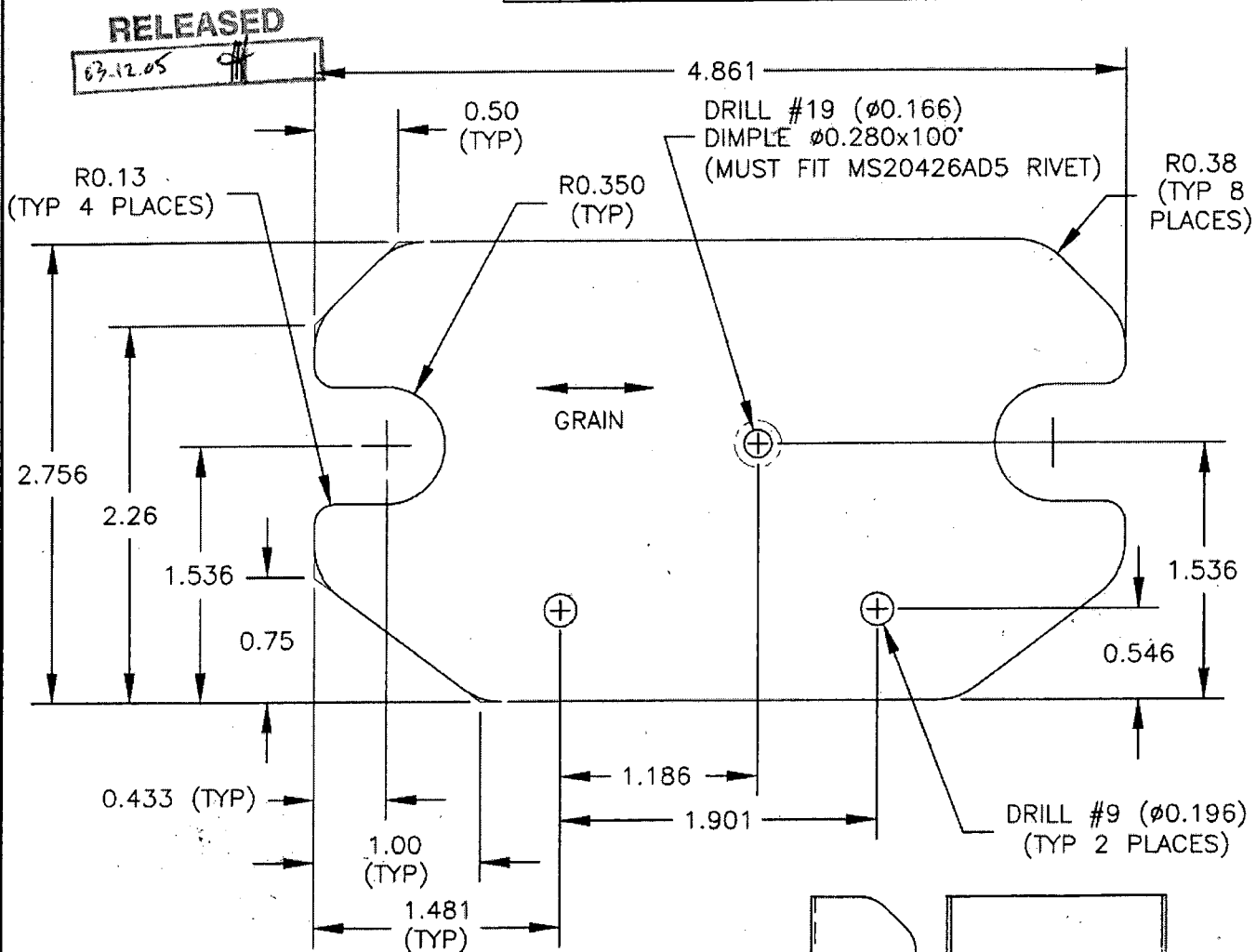
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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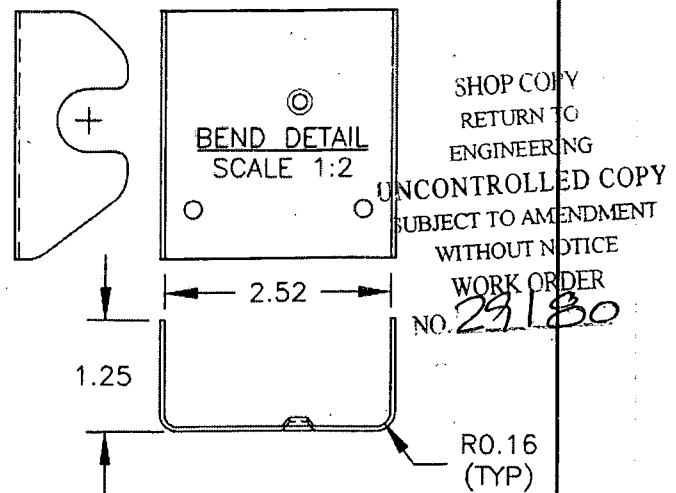
NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>UP</i> | DRAWN BY <i>UP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3225 | REV. A SHEET 1 OF 2 |
| DATE 03.10.22 | | TITLE COUPLING BRACKET | SCALE 1:1 |
| A | 03.10.22 | NEW ISSUE | |

**D3225-1 BRACKET**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

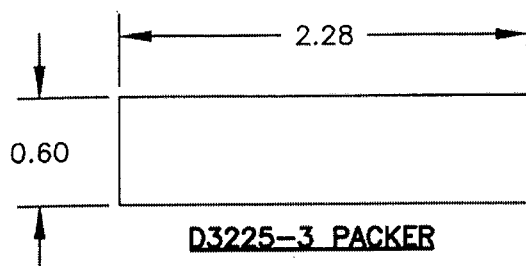


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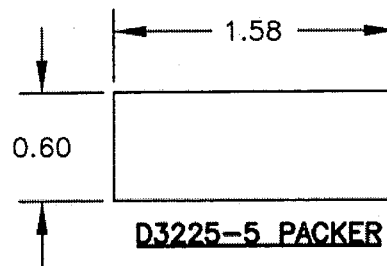
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| | | | |
|------------------|----------------|---|------------------------|
| DESIGN DP | DRAWN BY DP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED JH | APPROVED JH | DRAWING NO. D3225 | REV. A SHEET 2 OF 2 |
| DATE 03.10.22 | | TITLE COUPLING BRACKET | SCALE 1:1 |



D3225-3 PACKER



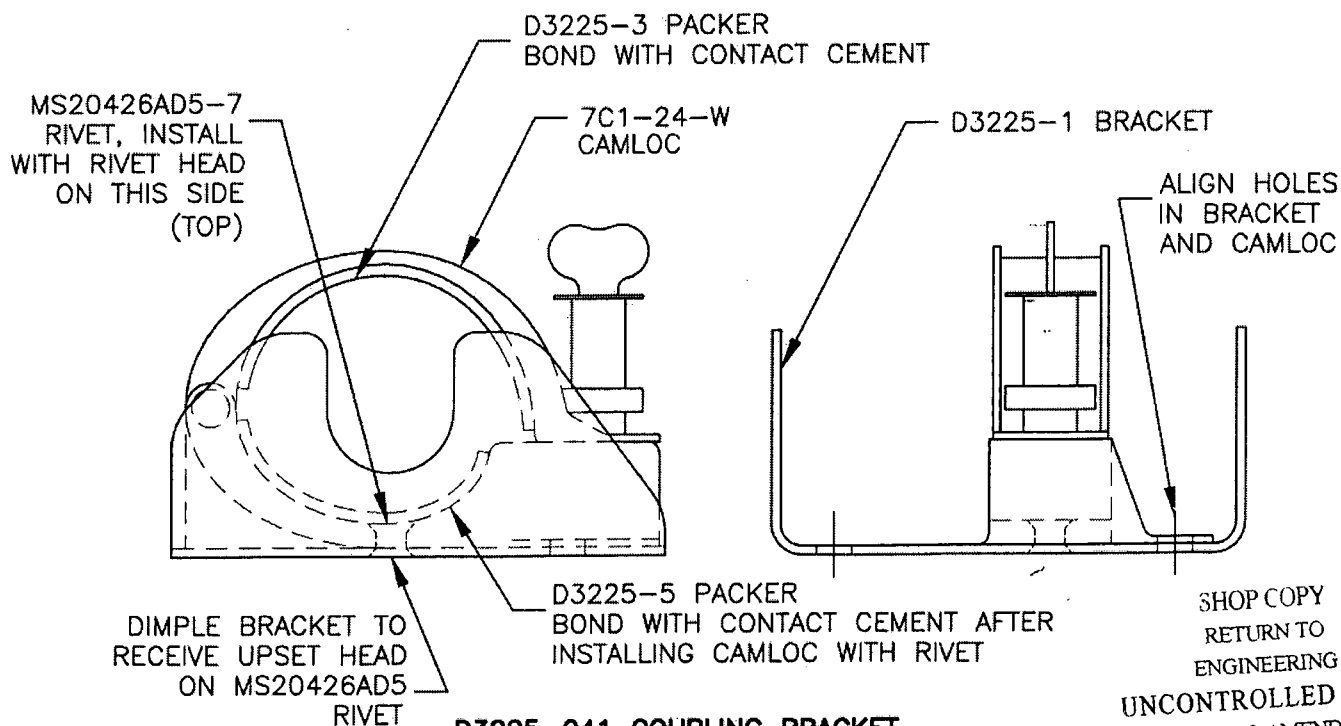
D3225-5 PACKER

D3225-3/-5 PACKER

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/16" THICK (D2397)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

03.12.05 JH



D3225-041 COUPLING BRACKET
(REPLACES HELITECH P/N 358-062-001)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29180

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